

Work Order ID 54585

December 14, 2009 1:10:45 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 14/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*Date: *12-14*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

PL 09-12-14

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

1 14/12/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54585

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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 14/12/2009 Start Qty: 1.09



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 - - AWM 9.12.30

① BE 12/01/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R: Aluminum Rod *ML12860*

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R: Aluminum Rod *ML12860*

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aff cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Towing using DT8091, open to .640" and Deburr

*BC 10/01/04**BC 10/01/04**10-01-08
AWM*

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Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
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DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ Sidelu

ⓧ



QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

⇒ Sidelu

ⓧ



QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00

BR 10-06-11

ⓧ



HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M113170

0.00

el 00-01-12

X1 0

Powder Coating

Memo

START TIME:

8:15AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:45AM

190

QC3- Inspect Part Finish

0.00



QC

BK 10-01-13

1 0

Quality Control

Memo

0.00

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 112345
Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 112345
Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 112900

BL 10-01-13 ①.

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



⇒ Scobility

QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

xl

f

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

PPD 51233 10-1-15

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/18

MF 10-1-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 54585

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube


Start Date: 14/12/2009

Required Date: 21/12/2009


Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Rou/ Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1		Manufactured	No			110	Each	7.0000	1.0000			
												
205 Skidtube bent detail												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	B54500	1 14/12/17
LG	4	
54120	2	
54279	2	
Main Warehouse		
ST	3	
53540	1	
54121	2	

D2576-3		Manufactured	No			140	Each	156.0000	1.0000			
												
Step (maching detail)												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	156	
43504	8	
46661	101	
52215	47	

1 BE 10/01/04

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Start Date: 14/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579		Manufactured	No			140	Each	363.0000	20.0000			



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

241

51525

4

53780

130

54543

107

Main Warehouse

ST

122

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

4 BE 10/01/04

16 BE 10/01/04

D2855

Manufactured No

200

Each

55.0000

1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

53791

55

50513

1

50770

3

51539

51

1 BL 10-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A 		Purchased	No			200	Each	2,027.000	2.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2027	
100188	188	
105057 ✓	1835	
15205	4	

2 BL 10-01-13

AN960JD10L 		Purchased	No			200	Each	5,427.000	2.0000			
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5427	
101291	16	
104885	153	
105793	236	
109632 ✓	268	
110985	4754	

2 BL 10-01-13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Qty: 1.00

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Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	2,080.000	50.0000			

Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	2080	
105855	16	
108606	52	
111529	688	
111779 ✓	313	
112772	11	
113238	1000	

50 BR 10-01-13.

AN3C4A

Purchased

No

200

Each

1,661.000

50.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1661	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	74	
113226 ✓	990	
113359	66	
113422 ✓	500	

46 BR 10-01-13.
4 BR 10-01-13.

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Shop Packet Print

Page 4

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Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Prim # Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	# Qty Issued	Date Issued	Status
AN960C10L 		Purchased	No			200	Each	500.0000	50.0000			
washer												

NAS1149C0332R

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
OFFSHORE		
FG	113288	
103585	100	
Main Warehouse		
ST	400	
112116	228	
112612	160	
112933	12	

50 BL 10-01-13.

D3566-13

Manufactured No

200

Each

100.0000 1.0000



Gasket

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP	98	
51606	15	
53461	83	
Main Warehouse		
ST	2	
45717	1	
50265	1	

1 BL 10-01-13.

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D3566-5		Manufactured	No			200	Each	26.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	22	
53804 ✓	22	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

D3566-1

Manufactured No

200 Each 22.0000 2.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP 54480	17	
52512	3	
53790	14	
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

W/O:		WORK ORDER CHANGES					
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D3564-11		Manufactured	No			200	Each	25.0000	1.0000			

Wearshoe

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP19	23	
52125 ✓	14	
53808	9	
Main Warehouse		
ST	2	
45823	1	
50112	1	

1 BX 10-01-13.

D3564-13

Manufactured No

200 Each 40.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP17	28	
51611 ✓	28	
Main Warehouse		
ST	12	
45409	2	
46495	10	

1 BR 10-01-13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 14, 2009 1:10:50 PM

Work Order ID: 54585

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 14/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Row Seq II	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9		Manufactured	No			200	Each	22.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

20

53806 ✓

20

Main Warehouse

ST

2

44659

1

45825

1

D3564-5

Manufactured No

200

Each

25.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

21

51925

1

53805 ✓

20

Main Warehouse

ST

2

45824

1

47433

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 14, 2009 1:10:50 PM

Work Order ID: 54585



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 14/12/2009

Required Date: 21/12/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3		Manufactured	No			200	Each	498.0000	16.0000			
O-Ring, 205 Skidtube												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

27

51613

27

Main Warehouse

ST

471

52562 ✓

471

D2594-1

Manufactured No

200

Each

281.0000

16.0000



Plug, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

121

54008

121

Main Warehouse

ST

160

42221

16

42807

92

43884

3

46435

2

51527

9

51757

38

16 12/10-01-B.

16 12/10-01-B.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54583

[Signature] 07-12-14

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

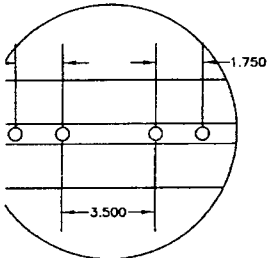
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

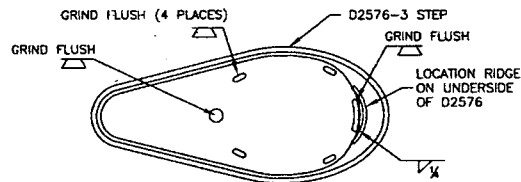
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

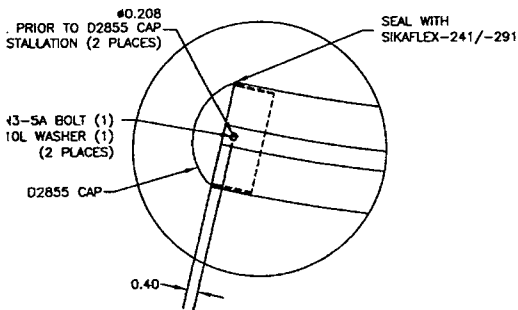


DETAIL B
SCALE 5:24

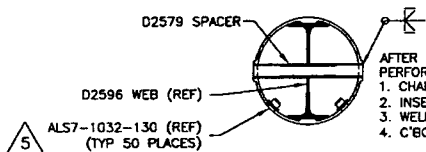


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07-06-28

DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



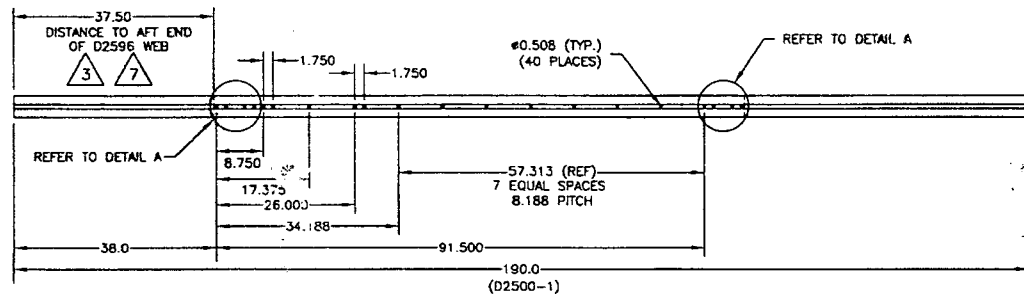
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

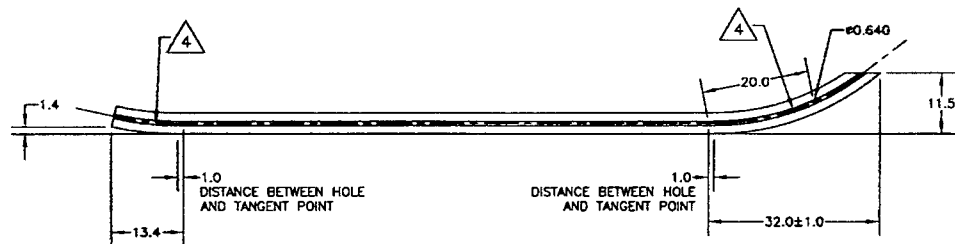
-041 NOTES

INISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

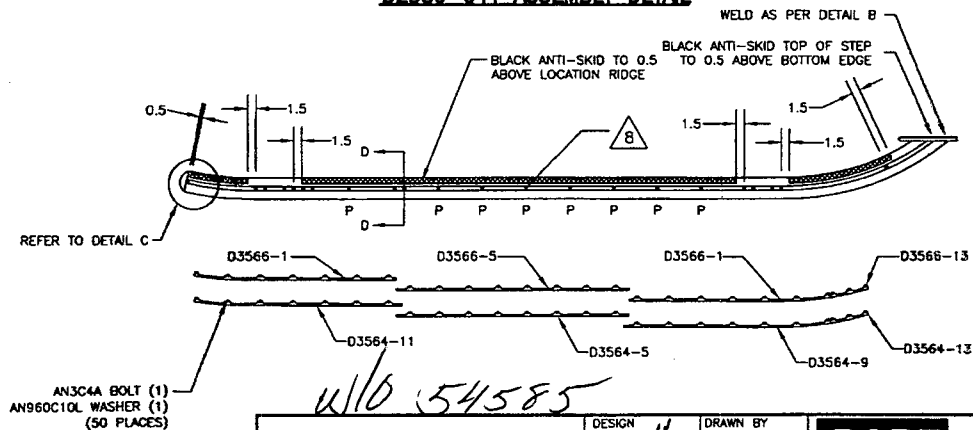
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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DESIGN

DRAWN BY

DART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

CHECKED *41*

APPROVED

DRAWING NO.

REV. D

DATE
07.02.27

TITLE
205 SKIDTUBE ASSEMBLY

SCALE
1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

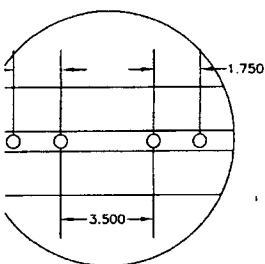
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

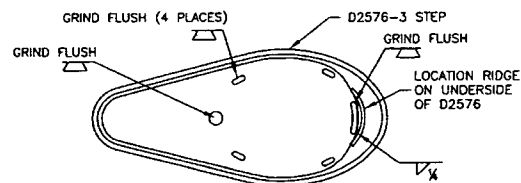
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SCALE 5:24

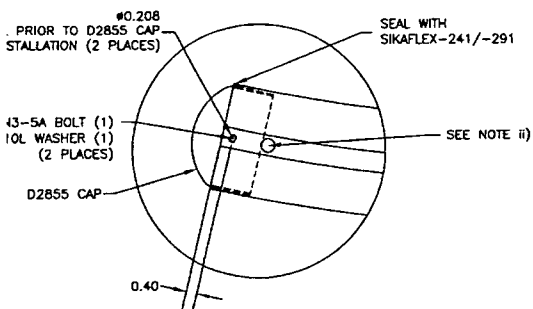


DETAIL F
SCALE 5:24

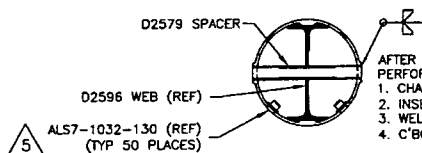


RELEASED
07 Dec 28

DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

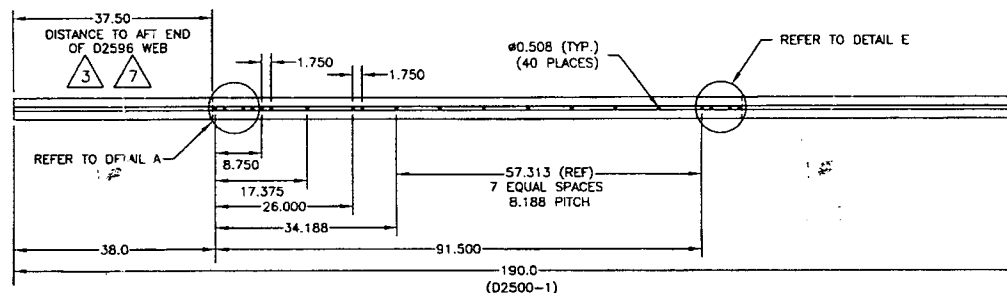
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

-045 NOTES

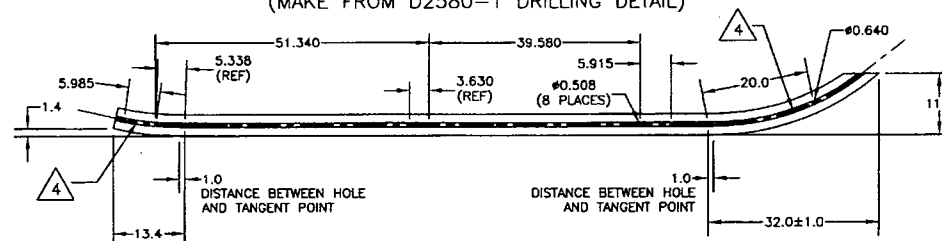
INISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

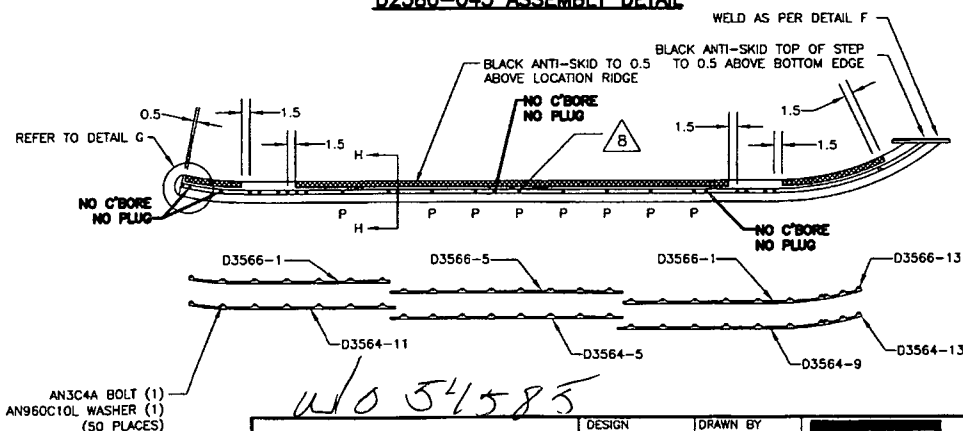
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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DESIGN

1

CHECKED

DATE _____

07.02.27

DRAWN BY

1 R

APPROVED

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

	DRAWING NO.
--	-------------

TITLE	
-------	--

205 SKIDTUBE ASSEMBLY

REV. D

SHEET 3 OF 3

SCALE

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 221

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berclay Elliott
Job number: 542020
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 09.12.17
Welder Berclay Elliott Date of Test Coupon 09.12.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld